

## DAFTAR PUSTAKA

Annual Report PT Pan Brothers Tbk 2018 HRD PT Eco Smart Garment Indonesia Klego.

Buku Pedoman Praktik Kerja Lapangan Akademi Komunitas Industri Tekstil dan Produk Tekstil Surakarta.

Habibah Permaysuri, Aynnaya. 2019. "Permasalahan dan Penyelesaian Proses Produksi *Women Pant S#229F032A*" dalam Laporan Praktik Kerja Lapangan PT Pan BrothersTbk.

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<https://britama.com/index.php/2012/12/sejarah-dan-profil-singkat-PBRX> diakses tanggal 5 Juni 2020

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# LAMPIRAN 1

## Line Balancing Worksheet Long Pants S#029A



### LINE BALANCE WORKSHEET

Date: \_\_\_\_\_  
By: \_\_\_\_\_

*Long Pants Line 2 Style 29*

|                |            |                |      |             |      |           |      |
|----------------|------------|----------------|------|-------------|------|-----------|------|
| FACTORY / LINE | ESSE LUMEN | Hourly Target  | 72   | Hourly Cap. | 72   | Plck Time | 0.00 |
| WUFD           | UNICOLD    | Takt Time      | 50   | YCT         | 0    | PK2       | 0.00 |
| PROL FAMILY    | PANTS      | Allowance rate | 10%  | Actual SMP  | 0.00 | GL        | 0.00 |
| WORKER No.     | BAHRIYAH   | PPH            |      | SMP BALANCE | 0.00 | GL        | 0.00 |
| WAP            | 48-01      | Efficiency     | 100% | SMP Sewing  | 0.00 | GL        | 0.00 |
| TARGET 100%    | 518        | Work hour      | 8.0  | OUTPUT 100% | 0.00 |           |      |
| TARGET 90%     | 518        |                |      |             |      |           |      |
| TARGET 80%     | 518        |                |      |             |      |           |      |

Ayufer  
100/13

Daily Production Report

| Cm. Process         | ISO code | Operator Name | Process name                                       | Machine  | Time Study |      |         | MP    | Process Rate | Process cap. 80 min |
|---------------------|----------|---------------|--|----------|------------|------|---------|-------|--------------|---------------------|
|                     |          |               |  |          | CT         | CTSM | EST ACT |       |              |                     |
| <b>A FRONT BODY</b> |          |               |  |          |            |      |         |       |              |                     |
| A1                  | NA       | BAHRIYAH      | MARKING FRONT BODY                                 | MMAC     | 2.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A2                  | NA       | BAHRIYAH      | CV CORN POCKET, KNEECLE                            | DM3      | 1.2        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| A3                  | NA       | BAHRIYAH      | STITCH HEMMING CORN POCKET                         | SM       | 2.0        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| A4                  | NA       | BAHRIYAH      | STITCH PAM SIDE POCKET                             | SM       | 4.0        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A5                  | NA       | BAHRIYAH      | STITCH KNEECLE SIDE POCKET + MARKING PAM           | SM       | 4.0        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A6                  | NA       | BAHRIYAH      | MARKING POSITION CORN + JOHN STITCH CORN POCKET    | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A7                  | NA       | BAHRIYAH      | CV SIDE POCKET - L/SK                              | DM3      | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A8                  | NA       | BAHRIYAH      | TACK LEGGING POCKET + STITCH 1/4 IN SIDE POCKET    | SM       | 2.0        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A9                  | NA       | BAHRIYAH      | CVT ALLOWANCE BODY SIDE POCKET                     | DM       | 0.5        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| A10                 | NA       | BAHRIYAH      | JOHN SIDE POCKET                                   | SM       | 0.5        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| A11                 | NA       | BAHRIYAH      | STITCH 1/16 KNEECLE IN SIDE POCKET                 | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A12                 | NA       | BAHRIYAH      | TACK DASAR SIDE POCKET + ID BAPFA                  | SM       | 1.0        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A13                 | NA       | BAHRIYAH      | JOHN + STITCH STITCH                               | SM       | 1.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A14                 | NA       | BAHRIYAH      | DOYONGTANGIS L/SK                                  | DM3      | 2.0        | 0.00 | 0.00    | 1     | 0.00         |                     |
| <b>TOTAL</b>        |          |               |  |          |            | 0.00 | 0.00    | 12.0  |              |                     |
| <b>KAPASITAS</b>    |          |               |  |          |            |      |         |       |              |                     |
| #REV/CT             |          |               |  |          |            |      |         |       |              |                     |
| <b>B BACK BODY</b>  |          |               |  |          |            |      |         |       |              |                     |
| B1                  | NA       | BAHRIYAH      | BONOR BACK POCKET                                  | MMAC     | 1.0        | 0.00 | 0.00    | 1     | 0.00         |                     |
| B2                  | NA       | BAHRIYAH      | TACK SRETBGA BACK POCKET                           | MMAC     | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| B3                  | NA       | BAHRIYAH      | STITCH PAM + KNEECLE BACK POCKET                   | SM       | 1.0        | 0.00 | 0.00    | 1     | 0.00         |                     |
| B4                  | NA       | BAHRIYAH      | STEAM BACK POCKET, CORN POCKET, LATER FC           | DM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| B5                  | NA       | BAHRIYAH      | KEY HOLE BACK POCKET (copy 2 line) + KEY HOLE      | KEY HOLE | 0.5        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| B6                  | NA       | BAHRIYAH      | TACK BACK POCKET                                   | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| B7                  | NA       | BAHRIYAH      | CV BACK POCKET                                     | DM3      | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| B8                  | NA       | BAHRIYAH      | STITCH 1/4 IN BACK POCKET                          | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| B9                  | NA       | BAHRIYAH      | STITCH 1/16 IN BACK POCKET + MARKING               | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| B10                 | NA       | BAHRIYAH      | STITCH UPPER BACK POCKET + TACK CLOSE BACK POCKET  | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| <b>TOTAL</b>        |          |               |  |          |            | 0.00 | 0.00    | 8.5   |              |                     |
| <b>KAPASITAS</b>    |          |               |  |          |            |      |         |       |              |                     |
| #REV/CT             |          |               |  |          |            |      |         |       |              |                     |
| <b>A5 ASSEMBLY</b>  |          |               |  |          |            |      |         |       |              |                     |
| A51                 | NA       | BAHRIYAH      | TACK UPPER SIDE SEAM                               | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A52                 | NA       | BAHRIYAH      | JOHN SIDE SEAM                                     | DM3      | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A53                 | NA       | BAHRIYAH      | MARKING POSITION                                   | MMAC     | 0.5        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| A54                 | NA       | BAHRIYAH      | CVT ALLOWANCE HEMING                               | DM       | 0.5        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| A55                 | NA       | BAHRIYAH      | STEAM SIDE POCKET + HEMMING + GOURT                | DM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A56                 | NA       | BAHRIYAH      | STITCH 1/8 SIDE POCKET                             | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A57                 | NA       | BAHRIYAH      | BAPFAKE VARIAN D BACK POCKET                       | DM       | 0.5        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| A58                 | NA       | BAHRIYAH      | BAPFAKE SIDE POCKET, KEYHOLE                       | DM       | 0.5        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| A59                 | NA       | BAHRIYAH      | MARKING + STITCH LATER LIN SIDE POCKET             | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A60                 | NA       | BAHRIYAH      | JOHN IN SEAM                                       | DM3      | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A61                 | NA       | BAHRIYAH      | JOHN STITCH FC CVT + TACK CRITCH                   | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A62                 | NA       | BAHRIYAH      | STEAM W/B + FC CVT                                 | DM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A63                 | NA       | BAHRIYAH      | STEAM GOURT + FC CVT                               | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A64                 | NA       | BAHRIYAH      | JOHN BACK RESE                                     | DM3      | 0.5        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| A65                 | NA       | BAHRIYAH      | STITCH BACK RESE                                   | MMAC     | 0.5        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| A66                 | NA       | BAHRIYAH      | MARKING POSITION W/B + LDOOP + SET W/B             | MMAC     | 0.5        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| A67                 | NA       | BAHRIYAH      | ATTACH ZIPPER TO ELY                               | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A68                 | NA       | BAHRIYAH      | TACK LOOP TO BODY                                  | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A69                 | NA       | BAHRIYAH      | JOHN LEGGING GOURT TO BODY + JOHN W/B RIGHT        | SM       | 0.5        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| A70                 | NA       | BAHRIYAH      | STITCH 1/16 FRONT BODY TO GOURT                    | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A71                 | NA       | BAHRIYAH      | JOHN W/B TO BODY LEFT                              | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A72                 | NA       | BAHRIYAH      | CVT ALLOWANCE BODY W/B                             | DM       | 0.5        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| A73                 | NA       | BAHRIYAH      | ATTACH LABEL                                       | SM       | 0.5        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| A74                 | NA       | BAHRIYAH      | CROSS W/B LEFT + SAMBLING LABEL LDOOP              | SM       | 0.5        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| A75                 | NA       | BAHRIYAH      | TACK LDOOP TO UPPER W/B                            | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A76                 | NA       | BAHRIYAH      | STITCH WAIST ELY                                   | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A77                 | NA       | BAHRIYAH      | BAPFAKE UPPER LDOOP, CRITCH, FC, GOURT             | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A78                 | NA       | BAHRIYAH      | STITCH LOWER W/B                                   | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A79                 | NA       | BAHRIYAH      | STITCH HEMMING V                                   | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A80                 | NA       | BAHRIYAH      | TACK LOWER LDOOP TO BODY                           | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A81                 | NA       | BAHRIYAH      | KEY HOLE W/B (copy 2 line)                         | KEY HOLE | 0.5        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| A82                 | NA       | BAHRIYAH      | KEY HOLE GOURT (copy 2 line)                       | KEY HOLE | 0.5        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| A83                 | NA       | BAHRIYAH      | TRIMMING   | MMAC     | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| A84                 | NA       | BAHRIYAH      | DOY TRIMMING                                       | MMAC     | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| <b>TOTAL</b>        |          |               |  |          |            | 0.00 | 0.00    | 29.5  |              |                     |
| <b>KAPASITAS</b>    |          |               |  |          |            |      |         |       |              |                     |
| #REV/CT             |          |               |  |          |            |      |         |       |              |                     |
| <b>W WAISTBAND</b>  |          |               |  |          |            |      |         |       |              |                     |
| W1                  | NA       | BAHRIYAH      | MARKING W/B  | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| W2                  | NA       | BAHRIYAH      | PPRING ELY   | DM       | 0.5        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| W3                  | NA       | BAHRIYAH      | JOHN LATER GOURT + TACK LEGGING GOURT              | SM       | 0.5        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| W4                  | NA       | BAHRIYAH      | ACROUC GOURT                                       | SM       | 0.5        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| W5                  | NA       | BAHRIYAH      | TACK LEGGING GOURT + CROSS W/B                     | SM       | 0.5        | 0.00 | 0.00    | 0.5   | 0.00         |                     |
| W6                  | NA       | BAHRIYAH      | STITCH UPPER LOWER W/B                             | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| W7                  | NA       | BAHRIYAH      | ATTACH ZIPPER TO GOURT + STITCH 1/16 LEGGING GOURT | SM       | 0.5        | 0.00 | 0.00    | 1     | 0.00         |                     |
| <b>TOTAL</b>        |          |               |  |          |            | 0.00 | 0.00    | 5.0   |              |                     |
| <b>KAPASITAS</b>    |          |               |  |          |            |      |         |       |              |                     |
| #REV/CT             |          |               |  |          |            |      |         |       |              |                     |
| <b>GRAND TOTAL</b>  |          |               |  |          |            | 0.00 | 0.00    | 35.00 |              |                     |

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|        |                  |     |    |                |      |
|--------|------------------|-----|----|----------------|------|
| GRUP 1 | ON ANKLE + BONOR | DM3 | A1 | HELPER SET PAM | GRUP |
|--------|------------------|-----|----|----------------|------|